



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2873-045
Job Sheet 186225



Part No: D2873-045

Job Qty: 20 ea

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Machining-1		mmml 18/12/02
100	Bandsaw	20 pcs	12/7/18	12/7/18	0.00	0.18	Bandsaw1		
110	CNC Vertical Machining	20 pcs	12/7/18	12/7/18	0.09	5.08	HAAS1-2		18-12-5
120	QC	20 pcs	12/7/18	12/7/18	0.00	0.00	QC2 Machining-1		18-12-5
130	QC	20 pcs	12/7/18	12/7/18	0.00	0.00	QC8 Machining-1		18/12/12
140	Small Fab	20 pcs	12/7/18	12/7/18	0.00	0.56	Small Fab-2		
150	QC	20 pcs	12/7/18	12/7/18	0.00	0.00	QC5	U1A 38	
160	HandFinish	20 pcs	12/7/18	12/7/18	0.00	0.41	HandFinish1	9-89	D.BAS 18/12/18
170	QC	20 pcs	12/7/18	12/7/18	0.00	0.00	QC7-1		36 DAS
180	Small Fab	20 pcs	12/7/18	12/7/18	0.00	0.56	Small Fab-2		9-89 DAS 36
190	QC	20 pcs	12/7/18	12/7/18	0.00	0.00	QC5		38 9-89
200	Packaging	20 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-1	LG050	18-12-20
210	QC21-SA	20 Ea	12/7/18	12/7/18	0.00	0.00	QC21		21 DEC 7 0 2018

Part Op 100 - Cut blanks: 1.000" x 0.375" x 2.700" long

Descriptions: 110 - Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev _____ F1819Folio Rev _____

140 - 1-Debur

180 - 1-Assemble as per Dwg D2873 2-Identify as D2873-045

200 - LOCATION : LG050

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	4.5000 ft (.225 ea)	90-Start up Operation	5127976 = 4.59
MS20426AD4-6	Rivet	80 Ea (4 ea)	180-Small Fab	5093088-5
MS21075L5	Nut Plate	40 Ea (2 ea)	180-Small Fab	5133199380
				5093720 (20)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.375X1.000	5	18	0
180-Small Fab	MS20426AD4-6	80	1,775	0
	MS21075L5	40	284	0



Container No: S133728



Part: D2873-045
Job No: 186225

Dart Aerospace Ltd.
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CANADA
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Specifications

Plex 11/13/18 9:07 AM Dart.lajeunesse.marie

WORK ORDER NON-CONFORMANCE

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tub Machinir Thermoformin Large Fa
Date :	Step #:	QTY Effe

Description Work Order Deviation

QC / QA Coordinator
Approval

Root Cause

FAULT CATEGORY

Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions
Doc/Data	Offset/Set-up	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence
Past Expiry Date	Manufacturing Process				
Misidentified	Past Due	OTHER :			

Specifications could not be found.

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

DART AEROSPACE LTD		Work Order:	186225
Description: Radius Block		Part Number:	D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.505	✓		CNC20	
1.000	+/-0.010	1.000	✓		CNC20	
0.750	+/-0.010	.752	✓		CNC20	
0.250	+/-0.010	.252	✓		CNC20	
1.000	+/-0.010	1.000	✓		CNC20	
2.000	+/-0.010	2.000	✓		CNC20	
Ø0.128	+0.005/-0.001	.132	✓		Pin	
0.359	+/-0.010	.359	✓		CNC20	
Ø0.316	+0.006/-0.001	.319	✓		Pin	
1.000	+/-0.010	1.000	✓		CNC20	
0.250	+/-0.010	.247	✓		CNC20	
0.061	+/-0.010	.063	✓		CNC20	
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.233	✓		CNC20	
		Ø.127	✓		CNC20	

Measured by:	<i>[Signature]</i>	Audited by:		Prototype Approval:	N/A
Date:	16-12-5	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM	<i>[Signature]</i>

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